

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 SKIDTUBE		
Job Number	: 28687				
Estimate Number	: 10465				
P.O. Number	: N/A	Part Number	: D058672011		
This Issue	: 9/21/2006 S.O. No. : N/A	Drawing Number	: N/A		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A		
Previous Run	: 28686	Material	: N/A		
Written By	: _____	Due Date	: 10/15/2006	Qty:	1 Um: Each
Checked & Approved By	: _____				
Comment	: Est Rev:F 02.06.24 Re-format; CHG002 (MPP2251); ECN 258 K				

Job Number:

1.0 DC DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-011 CHG002

2.0	28687A	0H-58 SKIDTUBE ASSEMBLY
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Pick Packing Kit

4.0 D2652 Bushing

Pick: Packing Kit

Batch =

Bushing

5.0 D2659 Lug Assembly

Pick: Packing Kit

Batch

Lug Assembly

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:19:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 28687

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 10 D2712

Set Screw

B26796 -

7.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2935

Saddle Spacer

B28265 -

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2934

Saddle Spacer

B28264 -

9.0

D29331

206 Saddle Left



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2933-1

Saddle

B28860 -

10.0

D29321

206 Saddle Left side



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2932-1

Saddle

B27140 410

11.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 1 D2968-043

Tow Ring

B28268 -

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 28687

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch =

✓ 4

AN3-37A

Bolt

M14978 -

13.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 8

AN3-41A

Bolt

M16271 -

14.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 12

AN4-6A

Bolt

M101418 -

15.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 4

AN5-10A

Bolt

M101840 -

16.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 4

AN5-12A

Bolt

M101069 -

17.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 12

AN960JD10

Washer

M100743 -

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 28687

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 24 AN960JD416 Washer M102339

19.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 8 AN960JD516 Washer M102328

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 1 AN970-4 Washer M100181

21.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 12 MS21042L3 Nut (or -3) M101917

22.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 13 MS21042L4 Nut (or -4) M19099

Revised 11/06 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *P* Date: 06/11/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 9/21/2006 3:19:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 28687

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 06/11/06

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-672-011

Location: _____

REV A

LB 06/11/07 ①

25.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

LB 06/11/08

Job Completion



LB 06/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:20:16 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OH-58 SKIDTUBE ASSEMBLY
Job Number : 28687A	
Estimate Number : 10475	
P.O. Number :	Part Number : D058672041
This Issue : 9/21/2006 S.O. No. :	Drawing Number : D2922 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LANDING GEAR	Drawing Revision : A1
Previous Run : 28686A	Material :
Written By :	Due Date : 10/15/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: C 02.06.28 Re-format; ECN 258 KJ Est Rev: D 06.02.06 Added Dt8025 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D058-672-041 CHG 001

N/A

2.0

D2620

Bent 206 Skidtube

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620

Bent Tube 3" OD

B28457

Pm' 06-10-10

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

**Comment:** LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

Pm' 06-10-10

2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R Aluminum Rod

m101055/m101010 BE 06-10-10

3-Cut aft end of D2620 bent tube as per dwg D2922

Pm' 06-10-11

4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia.

Pm' 06-10-11

5-Drill holes for wearplates using DT 8487 Open to 0.297" dia.

Pm' 06-10-11

6-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit

Pm' 06-10-11

8-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922

Pm' 06-10-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Thursday, 9/21/2006 3:20:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28687A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Deburr and Blow out all chips form inside the tube

Pm' 06-10-11 ①

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 10 11 ①

5.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2923 Web

B28696 Pm' 06-10-13 ①

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid) *Pm' 06-10-11 ①*

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid) *Pm' 06-10-11 ①*

3-Deburr and Blow out all chips from inside the tube *Pm' 06-10-11 ①*

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R Sikaflex-291

Sikaflex expire date: *06-10-21 Pm'*

07-02-01

Pm' 06-10-13 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-10-16

8.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number Description

1 D2794 Fwd Cap

Batch

B14400 BE 06-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:20:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28687A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 D2649

Crossbolt spacer

B 28250 BE 06-10-16

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922.(Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

M 101010 BE 06-10-16

3-Grind welds flush as per Dwg D2922

Prm 06-10-16

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

Prm 06-10-16

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Joe 10-17-01

PD 06-10-17 ①

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 11 01 ①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m. 06/12/01 ①

14.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

5 D2648-3

Wearpad

B 27149

a.m. 06/11/01 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28687A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-15 Wearshoe

B 24845

16.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-21 Wearshoe

B 27075

17.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2924 Wearshoe

B 2425

B 27127

18.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 MS27039-1-08 Screw

(S) M 102854 M 102404 (S)

19.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 AN960JD10L Washer

M 100233

a.m 06/11/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28687A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

50 ALS4-1032-130 Insert

M18990

or (see QSI 017)

21.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-1 Plugs

B28251

22.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-3 O-Rings

B25866

23.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

B28041

24.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

m102404

a.m 06/11/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DB Date: 06/14/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28687A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer *m100233*

a.m

06/10/01

①

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

m102107

Sikaflex expire date: *02/07*

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive.Clean excess adhesive

A/R Sikaflex-291

m102107

Sikaflex expire date: *02/07*

a.m

06/11/01

①

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

102098

Batch:

FC

06 11 01

①

27.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

1009/11/02

①

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *n/a*

n/a

04/11/06

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/07

①

Job Completion



U 06/11/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
A1	[Signature] 01.08.20	Ø0.640 WAS Ø0.625	

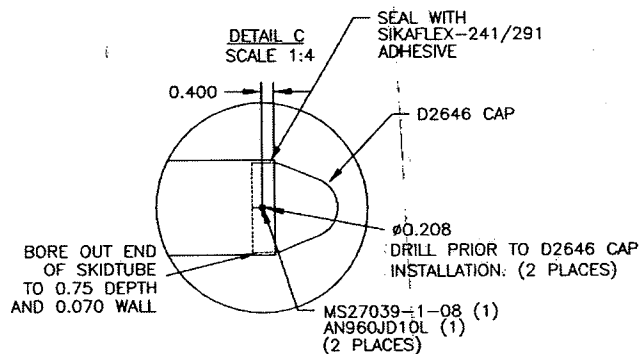
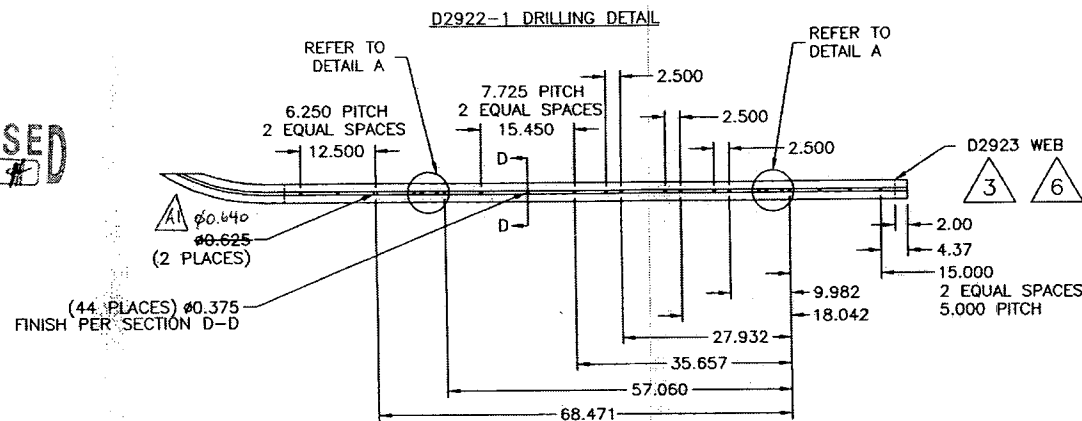
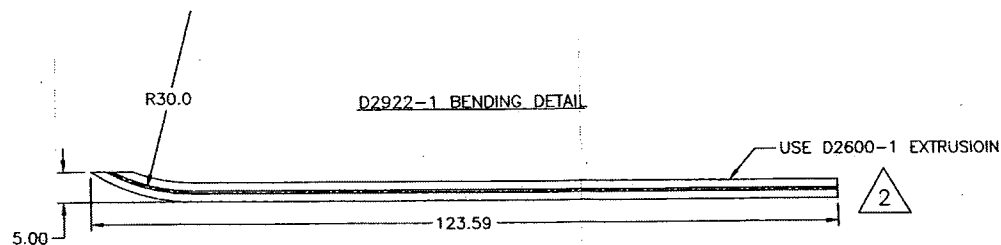
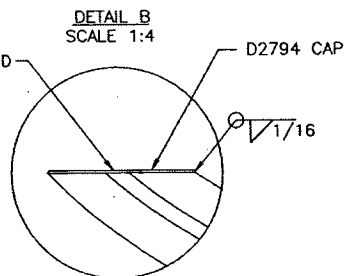
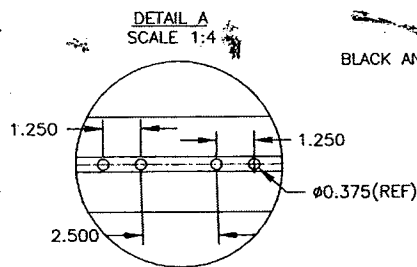
RELEASED
00.05.11 [Signature]

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

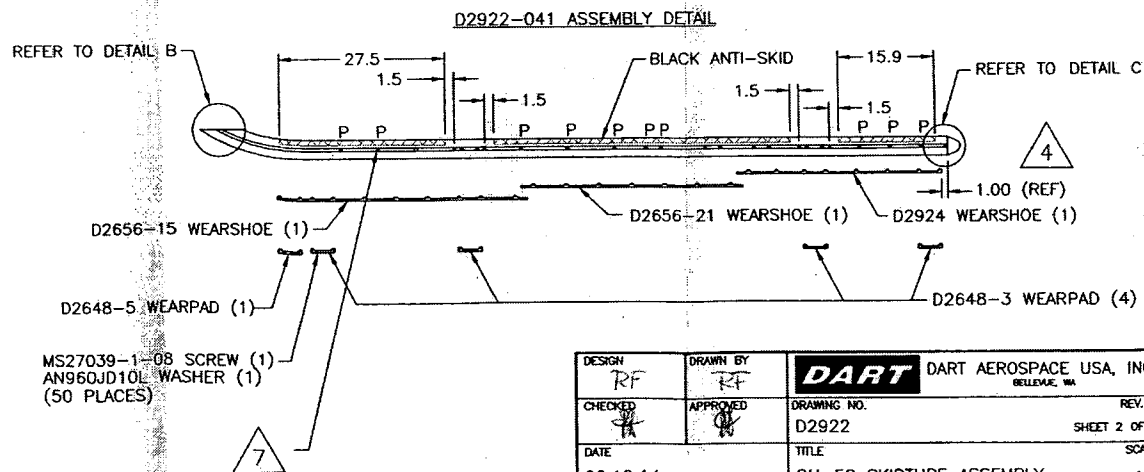
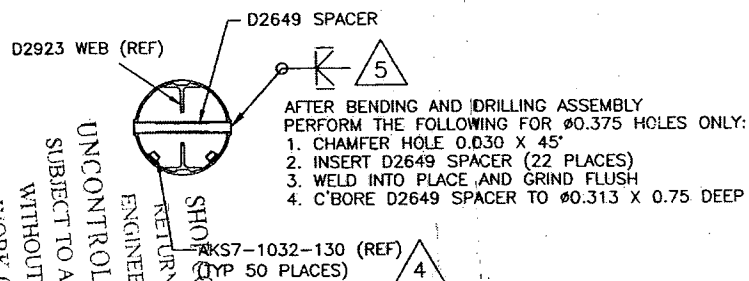
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE, INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

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SUBJECT TO AMENDMENT



SECTION D-D
SCALE 1:4
FOR 0.375 HOLES ONLY



DESIGN RF	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA	
CHECKED TH	APPROVED TH	DRAWING NO. D2922	REV. A SHEET 2 OF 2
DATE 99.10.14	TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE 1:20	

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AKS7-1032-130 (REF)
P 50 PLACES)

RELEASED
00.05.11

NO. 35

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure TIG
Part number and Job number AO58672041 1/B 28687 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/16 Qualifier David Arnold